

34 ✓

Order 12/42



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada
Tel (613) 632-5200
Fax 613 632-5246

RB6796941-201-3
Job Sheet 188696



Part No: RB6796941-201-3

Job Qty: 12 pcs

Part Name: Plug



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/14/19

Job Tracking No:

Due Date: 2/8/19

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG RB6796941-201 Rev2 IPP Rev A 17.12.05 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter / Supplier	Sign-off
					Setup Hrs	Run Hrs		
110	SL-154 - 1	12 pcs	2/8/19	2/8/19	0.00	4.00	SL-154 - 1	JB 19.02.11
120	QC 2	12 pcs	2/8/19	2/8/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 38	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 54	
							QC 2 - 56	
							QC 2 - 57	
							QC 2 - 62	JB 19.02.11
							QC 2 - 63	
							QC 2 - 8	

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 02/11/19

Container No: S152275
Part: RB6796941-201-3
Job No: 188696
Serial No/Batch: S152275
Revision: 2
Inspector:
Exp Date:
Instructions:



130 QC 8	12 pcs	2/8/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 38	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	D.P 19-02-11
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
140 QC 5	12 pcs	2/8/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 38	
				QC 5 - 42	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
150 Outsource - 12 - Black Oxide	12 pcs	2/8/19		GRO002-VC	10 0219-02-12
151 Packaging 2-1 - Receive - B4B	12 pcs Df	2/8/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	Df FEB 20 2019
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	

				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
152 QC 6	12 pcs	2/8/19	0.00 0.00	QC 6 - 38	
				QC 6 - 42	
				QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
153 Packaging 3-1 - Stock - B4B	12 pcs	2/8/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	12 pcs	2/8/19	0.00 0.00	QC 21 - SA - 21	

DAS
FEB 20 2019
58
9-89

DAS
28
9-89

DAS
21
FEB 21 2019

Part Op **110** - SL-154 (MORI SL-154 LATHE) 1-Machine as per folio FB 701 FOLIO REV: _____ DWG REV: _____
 Descriptions: _____ 2-Deburr

120 - QC2 Machining-4 (QC2- Inspect parts off machine FAI/FAIB)

130 - QC8 Machining-4 (QC8- Inspect parts - second check)

140 - QC5 (QC5- Inspect part completeness to step on W/O)

150 - Outsource12 (Outside Processing - Black Oxide) -Issue P/O to Groupe Altech; PO 04287X -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required

151 - Packaging2 (Receive & Inspect for Damage & Mat'l Certs)

152 - QC6 (QC6- All purchased or subcontracted products)

153 - Packaging3-2 (Identify as per dwg & Stock Location: _____)

190 - QC21 (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-1144-R0.625	AISI 1144 Stressproof Round Bar 0.625"	1.9200 ft (.16 ea)	110-SL-154 - 1	<u>5000803</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-SL-154 - 1	MT-1144-R0.625	2	6	0

MAT009-A

Part Specifications

Specifications could not be found.



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Job Sheet 188696



Part No: RB6796941-201-3

Job Qty: 12 ea

Part Name: Plug



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/14/19

Job Tracking No:

Due Date: 2/8/19

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG RB6796941-201 Rev2 IPP Rev A 17.12.05 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea		2/8/19	0.00	0.00	Start Up Machining-3		
110	Mori Seiki	12 pcs		2/8/19	0.00	4.00	SL-154		
120	QC	12 pcs		2/8/19	0.00	0.00	QC2 Machining-4		
130	QC	12 pcs		2/8/19	0.00	0.00	QC8 Machining-4		
140	QC	12 pcs		2/8/19	0.00	0.00	QC5		
150	Outsource	12 pcs		2/8/19			GRO002-VC	10	
151	Packaging	12 pcs		2/8/19	0.00	0.00	Packaging2		
152	QC	12 pcs		2/8/19	0.00	0.00	QC6		
153	Packaging	12 pcs		2/8/19	0.00	0.00	Packaging3-2		
190	QC21-SA	12 Ea		2/8/19	0.00	0.00	QC21		

Part Op 110 - 1-Machine as per folio FB 701 FOLIO REV: _____ DWG REV: _____ 2-Debur
Descriptions: 150 - -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of
Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-1144-R0.625	AISI 1144 Stressproof Round Bar 0.625"	1.9200 ft (.16 ea)	90-Start up Operation	5000803

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-1144-R0.625	2	6	0

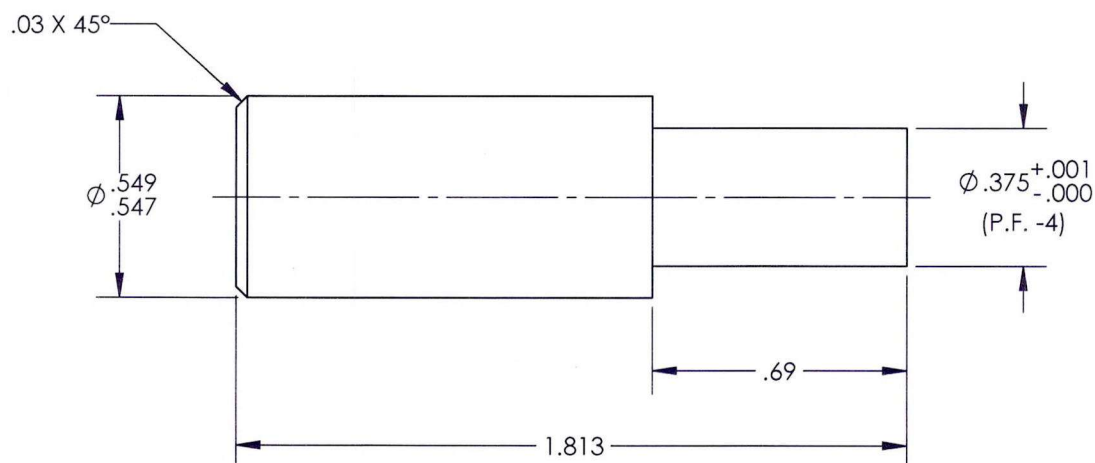
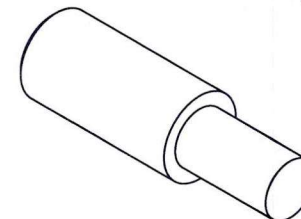
MAT009A

Part Specifications

Specifications could not be found.

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	17-0082	-3 ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D.	4/7/2017	RJC	JAG



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 188606 MGS
1901-14

(-3)
PLUG

DART AEROSPACE	
TITLE STARTER PULLER ASSY.	
DWG NO. RB6796941-201-3	REV 2
MAT'L STRESSPROOF	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH BLACK OXIDE	.XX ± .01 ANGLES ± 5°
SPEC QMSI-6.2.2, B.O. REV D	.X ± .1 SURFACES = 125/✓
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DD 04/07/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 04/10/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 04/10/2017	USED ON MODEL
APPROVED: JAG 04/13/2017	SEE NOTE 1, SHEET 1
SCALE 2:1	DATE 7/17/2000
SHEET 2 OF 3	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO042578



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO042578

PO Date: 2/12/19

Due Date: 2/19/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments: ** need lines 1&2 asap if possible **

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	180989	RB T101530-13	Base -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed -		2/15/19	6 pcs	0 pcs	6 pcs	\$3.52941/pcs	\$21.18
2	188696	RB6796941-201-3	Plug Outsource12 (Outside Processing - Black Oxide) -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed -		2/15/19	12 pcs	0 pcs	12 pcs	\$3.52941/pcs	\$42.35



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Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042578



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	189209	RBE350A93-3202-00-23	Washer -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; DOM -Certificate of Conformity is required	Firmed	-	2/19/19	14 pcs	0 pcs	14 pcs	\$3.52941/pcs	\$49.41
4	180989-A	RB T101530-13	Base -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	2/19/19	2 pcs	0 pcs	2 pcs	\$3.52941/pcs	\$7.06

Grand Total: \$120.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 2/13/19 8:23 AM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(016796-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

016796 - 1

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
18-Feb-2019		Aman		042578				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Quantités / Quantities				
				Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBT101530-13 Rev.	RBT101530-13 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OF OIL WIPE OFF EXCESS	OXIDE-BLACK CH	2	2	0	0	0
2	RB6796941-201-3 Rev.	PLUG BLACK OXIDE MIL-C-13924C CLASS 1	BLACK-OXIDE CH	12	12	0	0	0
3	RBE350A93-3202-00-23 Rev.	RBE350A93-3202-00-23 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-PRF-13924C CLASS 1 APPLY A THIN LAYER OF OIL WIPE OFF EXCESS	OXIDE-BLACK CH	14	14	0	0	0
4	RBT101530-13 Rev.	RBT101530-13 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OF OIL WIPE OFF EXCESS	OXIDE-BLACK CH	6	6	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.